

Date: Thursday, 5/10/2007 2:35:42 PM  
User: Kim Johnston

**Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : OUTER FWD SADDLE
Job Number : 32300	
Estimate Number : 11076	
P.O. Number : <i>N/A</i>	Part Number : D5951
This Issue : 5/10/2007 S.O. No. : <i>N/A</i>	Drawing Number : D5951 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 31528	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/5/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>14</i> Um: Each
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:E Re-Format 05-11-29 JLM	

**Additional Product**

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101013 Saddle billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
D6101-013 (7075-T7351)  
Size 2.50" x 10.10" X 8.25" (Grain along 10.10")  
Batch: *B25060*

*ml 07/06/19 14*

2.0 HAAS3 HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

- 1-Machine as per folio D5951, Ensure Batch Number is entered
- 2-Machine Keyway
- 3-Deburr & Tumble

*ml En / SA 07.06.17*

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*ml / En / SA 07.06.17*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*SG 07.06.19*

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*M-H 07/06/19*

*14X*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:35:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 32300

Part Number: D5951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



*M 10/14/4*



*(14)*

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BL / M/A 07-06-20*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*(14)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*EF*

*07/06/21*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*7/6/21 SP*

*(14)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



*(14)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/06/22*

Job Completion



*U 07/06/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>32300</b>
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b>	<b>D5951</b>
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.437	0.444		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.752	1.752	1.750		
C	5.245	5.255		5.250	5.252	5.251	5.250		
D	6.995	7.005		7.000	7.002	7.000	7.000		
E	5.745	5.755		5.749	5.750	5.750	5.750		
F	4.745	4.755		4.749	4.750	4.750	4.750		
G	<del>0.312</del>	<del>0.319</del>	3/15 → 3/22	0.320	0.320	0.320	0.320		
H	1.522	1.532		1.526	1.528	1.527	1.527		
I	3.048	3.058		3.053	3.055	3.054	3.054		
J	4.575	4.585		4.579	4.580	4.580	4.580		
K	<del>0.312</del>	<del>0.319</del>	3/15 → 3/22	0.320	0.320	0.320	0.320		
L	0.495	0.505		0.501	0.500	0.500	0.500		
M	0.490	0.510		0.502	0.500	0.499	0.502		
N	1.615	1.635		1.630	1.630	1.630	1.630		
O	7.990	8.010		7.996	7.992	8.003	8.001		
P	2.240	2.260		2.257	2.257	2.257	2.257		
Q	0.307	0.312		0.309	0.309	0.310	0.309		
R	0.760	0.765		0.765	0.765	0.765	0.765		
S	0.490	0.510		0.504	0.495	0.497	0.499		
T	1.375	1.395		1.390	1.389	1.389	1.389		
U	2.000	2.020		2.007	2.000	2.007	2.009		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>KJ/EC / SA</i>
Date:	<i>07/06/14</i>

Audited by:	<i>EC</i>
Date:	<i>07-06-14</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC <i>A</i>	<i>B</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32300
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b>	D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.001	6.999		
E	5.745	5.755		5.750	5.751	5.751	5.750		
F	4.745	4.755		4.752	4.749	4.751	4.750		
G	<del>0.312</del> 0.319	<del>0.319</del>	.315 → .322	.320	.320	.320	.320		
H	1.522	1.532		1.527	1.527	1.527	1.528		
I	3.048	3.058		3.054	3.057	3.054	3.054		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	<del>0.312</del> 0.319	<del>0.319</del>	.315 → .322	.320	.320	.320	.320		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.499	.501	.498	.499		
N	1.615	1.635		1.630	1.630	1.630	1.630		
O	7.990	8.010		8.001	8.002	7.999	8.000		
P	2.240	2.260		2.257	2.257	2.252	2.257		
Q	0.307	0.312		0.309	0.309	0.309	0.309		
R	0.760	0.765		.765	.765	.765	.765		
S	0.490	0.510		.497	.497	.497	.497		
T	1.375	1.395		1.386	1.387	1.387	1.391		
U	2.000	2.020		2.006	2.007	2.007	2.007		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	En / SA
Date:	07/06/17

Audited by:	SG
Date:	07-06-19

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	EA

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32300
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b>	D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.437	0.444		439	435	438	439		
B	1.745	1.755		1.750	1.750	1.751	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.25		
D	6.995	7.005		6.999	6.999	6.998	6.999		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.312	0.319	315-2.322	320	320	320	320		
H	1.522	1.532		1.527	1.527	1.525	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.312	0.319	315-322	320	320	320	320		
L	0.495	0.505		500	497	500	500		
M	0.490	0.510		497	493	494	495		
N	1.615	1.635		1.630	1.631	1.630	1.631		
O	7.990	8.010		7.998	7.998	8.000	7.998		
P	2.240	2.260		2.250	2.250	2.250	2.253		
Q	0.307	0.312		309	309	309	309		
R	0.760	0.765		762	762	762	762		
S	0.490	0.510		498	497	498	498		
T	1.375	1.395		1.387	1.388	1.387	1.388		
U	2.000	2.020		2.007	2.008	2.007	2.008		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	07-06-18

Audited by:	TS
Date:	07-06-19

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	BE

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 32300
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b> D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		0.440	0.440				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.745	5.755		5.748	5.750				
F	4.745	4.755		4.747	4.750				
G	0.312	0.319	0.315 → 0.322	0.320	0.320				
H	1.522	1.532		1.526	1.526				
	3.048	3.058		3.053	3.054				
J	4.575	4.585		4.580	4.580				
K	0.312	0.319	0.315 → 0.320	0.320	0.320				
L	0.495	0.505		0.499	0.499				
M	0.490	0.510		0.498	0.501				
N	1.615	1.635		1.635	1.635				
O	7.990	8.010		7.998	7.998				
P	2.240	2.260		2.260	2.260				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		0.760	0.760				
S	0.490	0.510		0.498	0.502				
T	1.375	1.395		1.380	1.381				
U	2.000	2.020		2.008	2.008				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD Pml
Date:	07.06.18

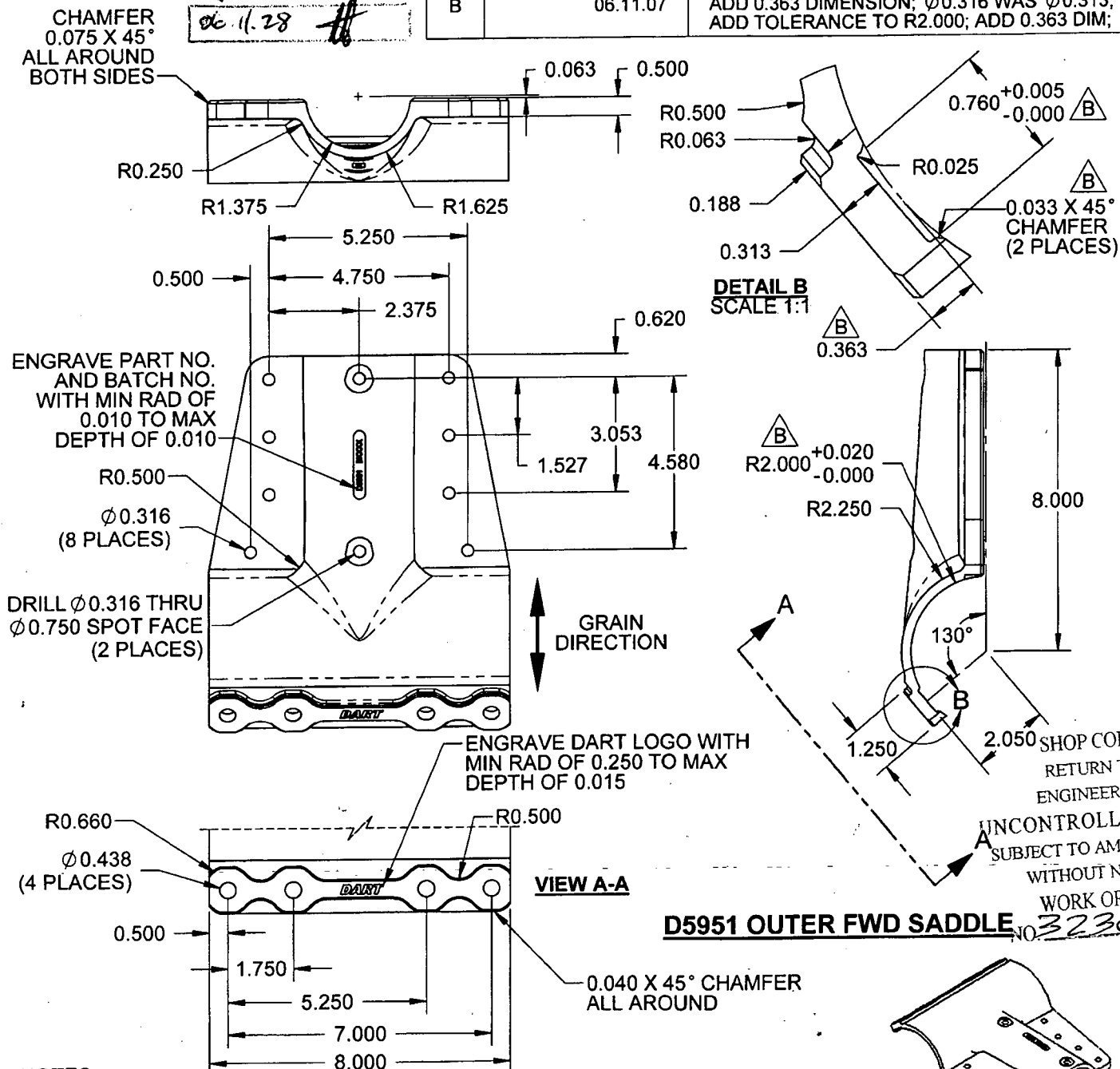
Audited by:	BC
Date:	07.06.19

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
E	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	EC

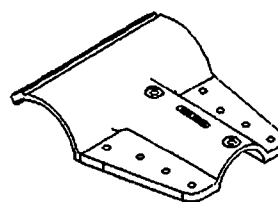


**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5951</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>OUTER FWD SADDLE</b>		SCALE 1:4
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>	
<b>B</b>	<b>06.11.07</b>	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**  
SCALE 1:8

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